

Ship Dec 23

Work Order ID 138815

138815

Page 1

Item ID: D212-725-1-069

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Stiffener

Start Date: 11/12/2015 Start Qty: 1.00

f 2 SH
f 2

Cust Item ID:

Required Date: 12/23/2015 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: SH Date: 20151112

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4222

A

100

0.00

100

Small Fab

Memo

0.00

Small Fab

1-Cut as per dwg

2-Make radius as pre dwg and deburr

2 FF DEC 03 2015

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

② DAS 38 9-89 DEC 03 2015

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

② DP 15-12-3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : _____																																																															

Work Order ID 138815

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138815

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Item ID: D212-725-1-069 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Stiffener
 Start Date: 11/12/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/23/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							DAS 38 9-89
130						(2)			DEC 07 2015
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>ST573</u>	0.00							
140									2 DEC 07 2015
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									ML5 DEC 08 2015
QC	Memo	0.00							
Quality Control									

ML5 DEC 07 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER :							

Picklist Print

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Work Order ID: 138815

138815

Parent Item: D212-725-1-069

D212-725-1-069

Parent Item Name: Stiffener

Start Date: 11/12/2015

Required Date: 12/23/2015

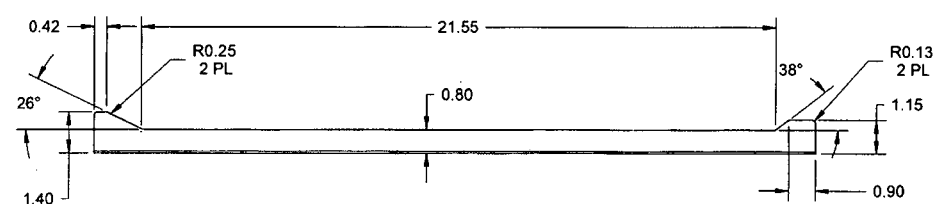
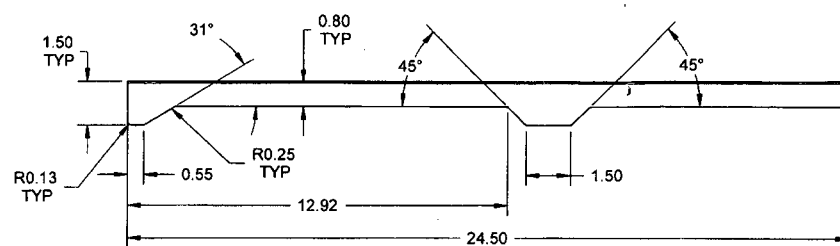
Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.10.28 as per dwg revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6A1.5X1.5X.06 3		Purchased		No			f	0.0000		2			
M7075T6A1 5X1 5X 063 7075T6 ANGLE 1.5" X 1.5" X .063"W M 133703 ** 2 FF DEC 02 2015													

M7075T6A1.5X1.5X.063
M133703



D212-725-1-069 STIFFENER

- NOTES:**
- 1) MATERIAL: 7075-T6/T6510/T6511/T62 ALUMINUM ANGLE, 0.063 THICK
PER AMS-QQ-A-200/11
PER DART SPEC. M7075T6A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.29 lbs

RELEASED
2011-08-25
WPD

SH20151112 138815

DESIGN	RF	DESCRIPTION	RF	11.02.24
DRAWN	RF		BY	DATE
CHECKED	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
MFG. APPR.	RF	DRAWING NO. D4222	REV. A SHEET 1 OF 1	
APPROVED	RF	TITLE	SCALE	
DE APPR.	RF	STIFFENER	NTS	
DATE	11.02.24	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

DART AEROSPACE LTD		Work Order: 138815
Description: Stiffener		Part Number: D212-725-1-069
Inspection Dwg: D212-725-1 Pg 27 of 44 Rev: B-1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.50	+/-0.030	24.50	✓		T.M.	
0.48 ?	+/-0.030					
1.50	+/-0.030	1.50	✓		S Feb-14	
0.80	+/-0.030	0.805	✓			
12.82	+/-0.030	12.82	✓		T.M.	
1.50	+/-0.030	1.50	✓		S Feb-14	
31°	+/-0.5°	30.8°	✓		S Feb-07	
45°	+/-0.5°	45°	✓		S Feb-07	
21.55	+/-0.030	21.56	✓		T.M.	
0.36 ?	+/-0.030					
0.97 ?	+/-0.030					
26°	+/-0.5°	25.7°	✓		S Feb-07	
38°	+/-0.5°	38°	✓		S Feb-07	
1.40	+/-0.030	1.398	✓		S Feb-14	
1.15	+/-0.030	1.154	✓		S Feb-14	
R0.13	+/-0.030	R0.13	✓			
R0.25	+/-0.030	R0.25	✓			

Measured by: FS	Audited by: DAS 30 9-89	Preliminary Approval:
Date: DEC 03 2015	Date: DEC 03 2015	Date:

Rev	Date	Change	Revised by	Approved
A	11.01.20	New Issue	KJ	